

Date: Thursday, 19/07/2007 9:01:58 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 33656	
Estimate Number : 10791	
P.O. Number : <i>NIA</i>	Part Number : D3282041
This Issue : 19/07/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 33373	Material : <i>NIA</i>
Written By : <i>[Signature]</i>	Due Date : 26/07/2007 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
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1 D2792-130 Extrusion

Identify as D3282-1

29030

7-7-19

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

7-7-19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

07/07/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/07/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/07/2007 9:01:58 AM
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Drawing Name: FLOAT WEB

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Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SL 07/07/23

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

R 7-7-23 (6)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

7-7-23

(6)

8.0 D32831 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 32477

(12)

R 7-7-23

9.0 MS20470AD47 Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 456.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M104291

(342)

R

7-7-23

10.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3

M104291

R 7-7-23 (6)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 02/07/23 x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 09/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/07/2007 9:01:58 AM
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Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 7-7-23

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

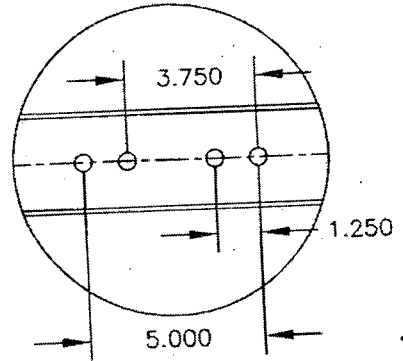
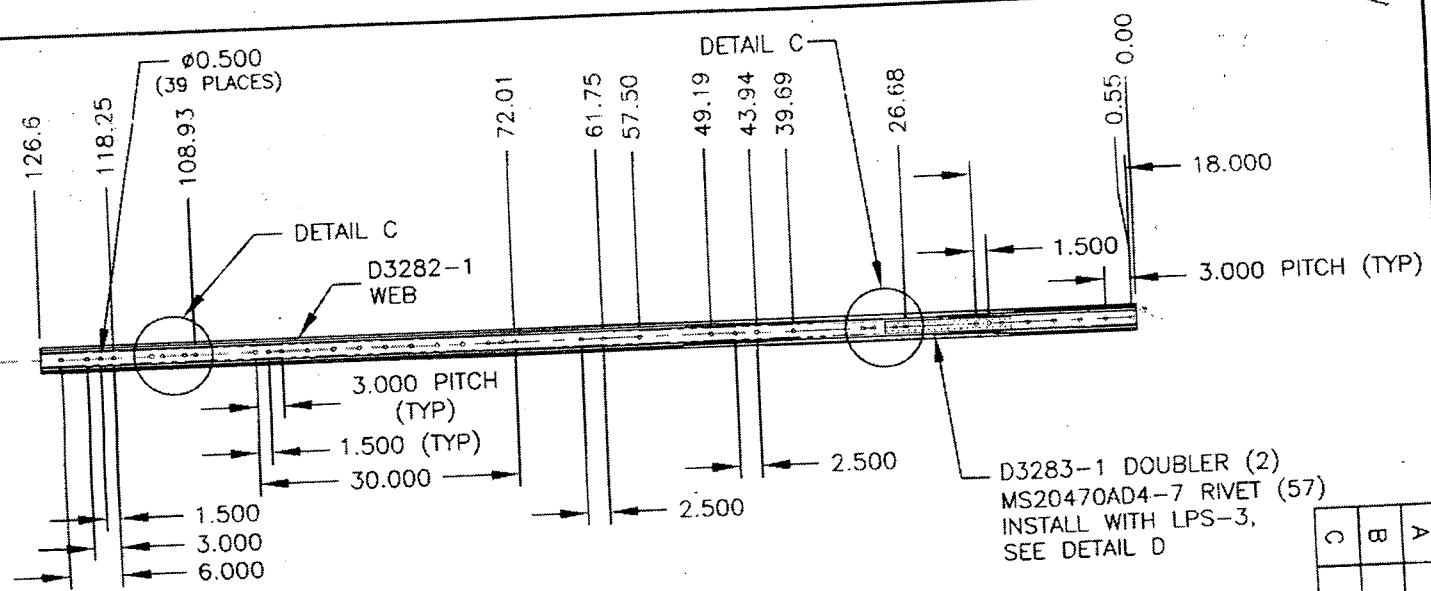
5/25/07/24

Job Completion

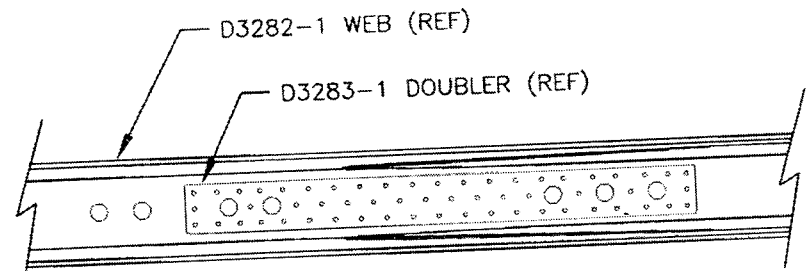


U 8-5-24

DART



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

DESIGN	DRAWN BY	TITLE	REV. C
CP	CP	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO. D3282	SHEET 1 OF 2
DATE			SCALE
05.08.09		04.05.05	1:20
		05.03.16	
		05.08.09	
		NEW ISSUE	
		MOVE HOLES, ADD D3390-1 DOUBLERS	
		REMOVE D3390-1, NOW MACHINED	

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

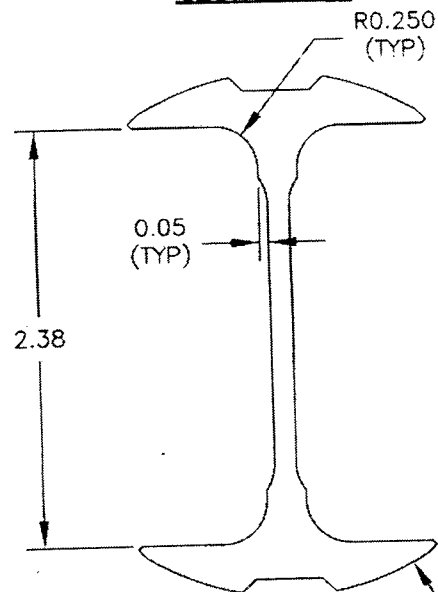
RELEASED
05.09.12

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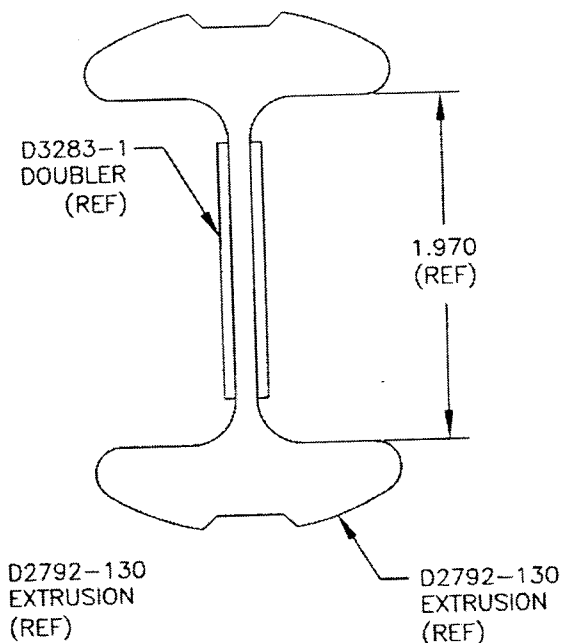
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	DRAWING NO.	D3282	REV. 0
		TITLE	FLOAT WEB, 206L/407	SHEET 2 OF 2
				SCALE
				1:20

SECTION A-A

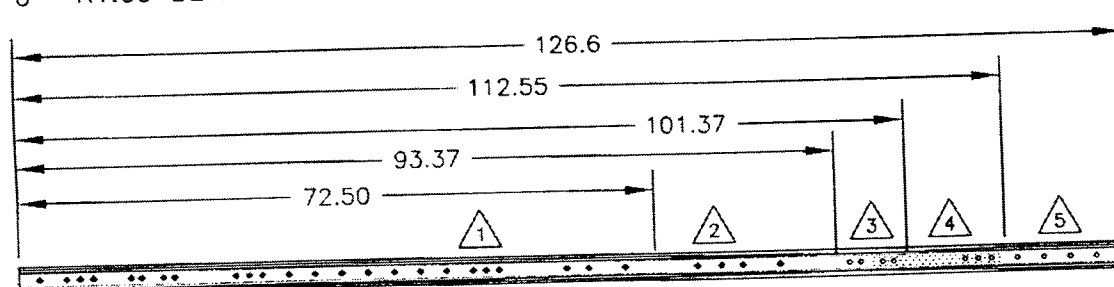


SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED

05-04-12

DART AEROSPACE LTD		Work Order:	33373
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.620	—			
1.500	+/-0.010	1.500	—			
3.000	+/-0.010	3.000	—			
6.000	+/-0.010	6.000	—			
1.250	+/-0.010	1.250	—			
30.000	+/-0.010	30.000	—			
1.500	+/-0.010	1.500	—			
72.01	+/-0.030	72.000	—			
61.75	+/-0.030	61.750	—			
57.50	+/-0.030	57.500	—			
49.19	+/-0.030	49.190	—			
43.94	+/-0.030	43.930	—			
39.69	+/-0.030	39.680	—			
26.68	+/-0.030	26.680	—			
0.55	+/-0.030	0.550	—			
1.970	+/-0.010	1.971	—			
2.38	+/-0.030	2.380	—			
0.05	+/-0.030	0.055	—			

Measured by: <i>JML</i> Date: 07/07/17	Audited by: <i>SA</i> Date: 01.01.19	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>